

Date: Wednesday, 1/24/2007 4:45:02 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HIGH AFT X-TUBE 412
Job Number	: 30424		
Estimate Number	: 10559		
P.O. Number	: N/A	Part Number	: D412664203
This Issue	: 1/24/2007 S.O. No. : N/A	Drawing Number	: D412-664-243 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 30191	Material	: N/A
Written By	: <u>07.01.25</u>	Due Date	: 2/28/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.01.25</u>		
Comment	Est Rev: E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev: F 06-03-29 Remove Comments on Pick List JLM est rev G 06.12.08 per ECN 886 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 005

07/05/04
 KS
 CHG 006
 07.01.25
 CL

2.0	D6009129	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B26548

Check OD = 3.500"; ID = 2.250"

7ml 07/02/01

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

En 07/02/02

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

En 07/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30424

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243
engrave on outside of tube)

Inside of Cuff(Donot

En 07-02-02

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

En 07-02-02

QC8

SECOND CHECK



Comment: SECOND CHECK

SN 07-02-05

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

fr/n

07-02-08

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-2-8

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE/n

07-02-08

11.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

DP 7-2-8

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30424

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP/EL 7-3-1

13.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/03/08

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

07/03/08
507-3-8

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

507-3-8

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/08
DP 7-3-8

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/08
LPI DP 7-3-8

18.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: 3449 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C207/03/300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30424

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CY 07/04/02 ①

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

07-04-02 ①

21.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 07-04-16

22.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

07-04-17 ①

23.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

326650 ml 07-07-09

24.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

30200

gt 07-07-10

25.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1

Chafing Shield

32573

ml 07-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.07.11	28	REPLACE D2732 Rubber Cushions with D3595-063-570 PER DWG DA12-664-243 Rev D				CP 07.07.11 08.047	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30424

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp M103896

M1070709

27.0

MS2192032

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 102931 RT 07-07-10

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0290 f(s)/Unit Total : 1.0290 f(s)

Rubber Extrusion

D3595-063-570 (07.07.11)

Cut qty 2 5.80" long

qty part # description batch

2 D2732-058 rubber cushion 32894

M1070711

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

Instal support with magnobond 6398 per dwg D412-664-203,
cure for 12hrs before packaging. B104723

Time & date of application: 2:30 07-07-10

RT 07-07-10

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/14/10

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30424

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M101124

M101297 X

33.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M101428

X

34.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M101697

X

35.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch: M101660

X

7/7/12 SP

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/7/12

U C807107/12 ①

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging:

7/7/12 11.45

Location:

PPP Rev:

6 7/7/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/07/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30424

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
H 07/07/13

Job Completion



u 07-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 30424
Description: Crosstube Assembly (412 High Aft)	Part Number: D412-664-243
Inspection Dwg: D412-664-243 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

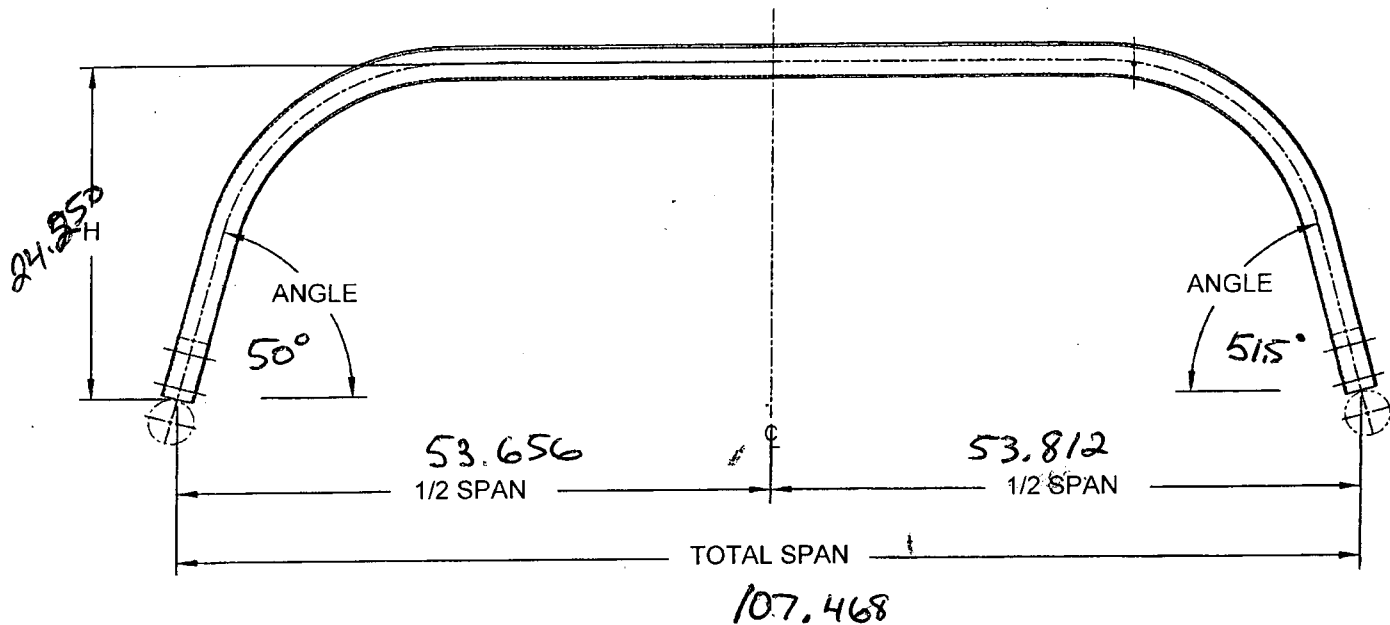
☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688				
	2.748	+0.005/-0.000	2.752				
	2.884	+0.005/-0.000	2.889				
	3.019	+0.005/-0.000	3.024				
	3.163	+0.005/-0.000	3.167				
	3.308	+0.005/-0.000	3.013				
	3.429	+0.005/-0.000	3.434				
	2.990	+0.005/-0.000	2.991				
	2.618	+0.005/-0.000	2.622				
	0.200	+/-0.010	0.208	—			
	R0.063	+/-0.010	R0.063	—			
	R0.500	+/-0.010	R0.500	—			
	4.971	+/-0.001	4.972				
SIDE B	2.684	+0.005/-0.000	2.690				
	2.748	+0.005/-0.000	2.753				
	2.884	+0.005/-0.000	2.888				
	3.019	+0.005/-0.000	3.024				
	3.163	+0.005/-0.000	3.168				
	3.308	+0.005/-0.000	3.312				
	3.429	+0.005/-0.000	3.434				
	2.990	+0.005/-0.000	2.992				
	2.618	+0.005/-0.000	2.622				
	0.200	+/-0.010	0.208	—			
	R0.063	+/-0.010	R0.063	—			
	R0.500	+/-0.010	R0.500	—			
	4.971	+/-0.001	4.972				
	124.09	+/-0.020	124.09				

Measured by: EN	Audited by: SD	Prototype Approval:	N/A
Date: 07/02/02	Date: 07.02.05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	

Crosstube Bend Dimension Sheet



PART NUMBER: 412664203

BATCH NUMBER: 30424

DRAWING 412664243 REVISION: C

H: 24.37

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50

QC 15: M

DATE: 07/03/08

QTY: 1

Fit in table jig



DESIGN PH	DRAWN BY AB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED AB	DRAWING NO. D412-664-243	REV. C SHEET 1 OF 3
DATE 06.10.27		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	

RELEASED
di 4-28 **AB**

PARTS LIST:

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D2732-058	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-32	CLAMP
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

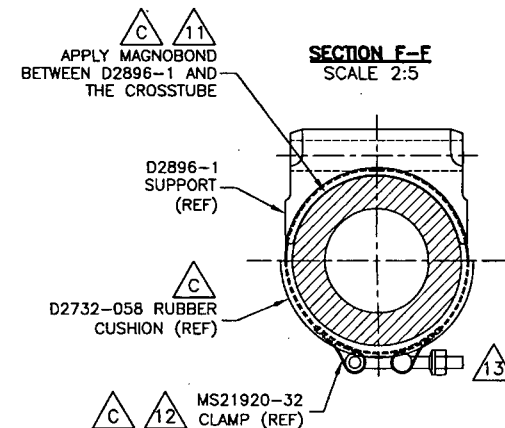
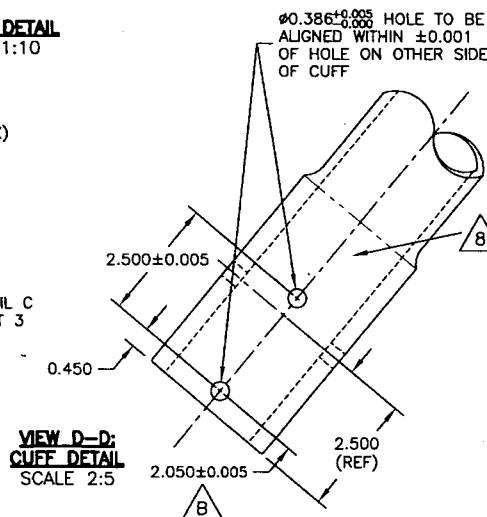
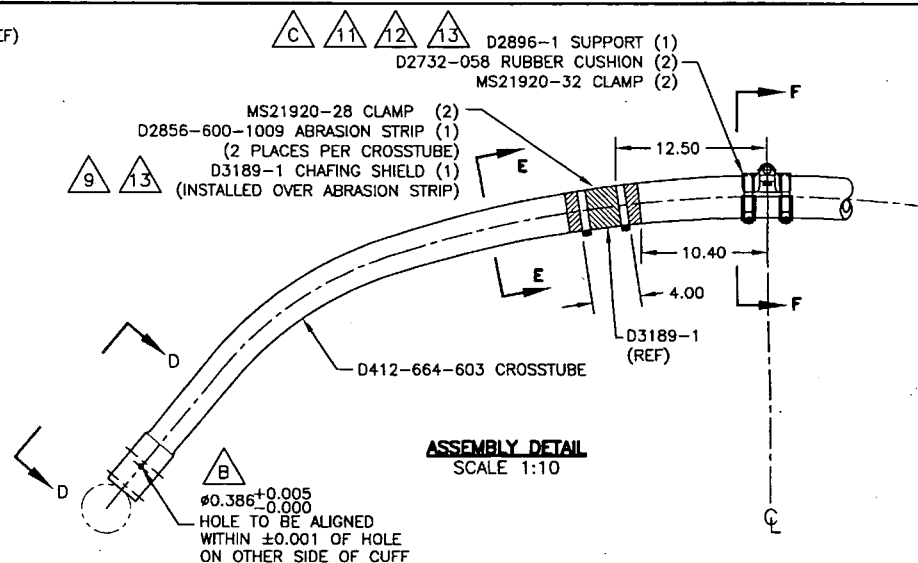
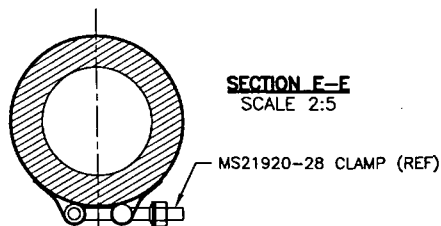
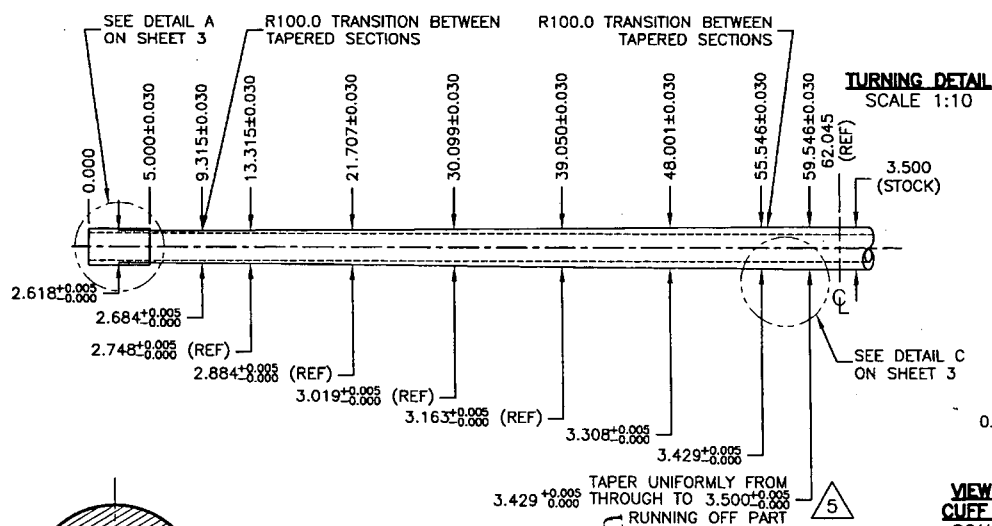
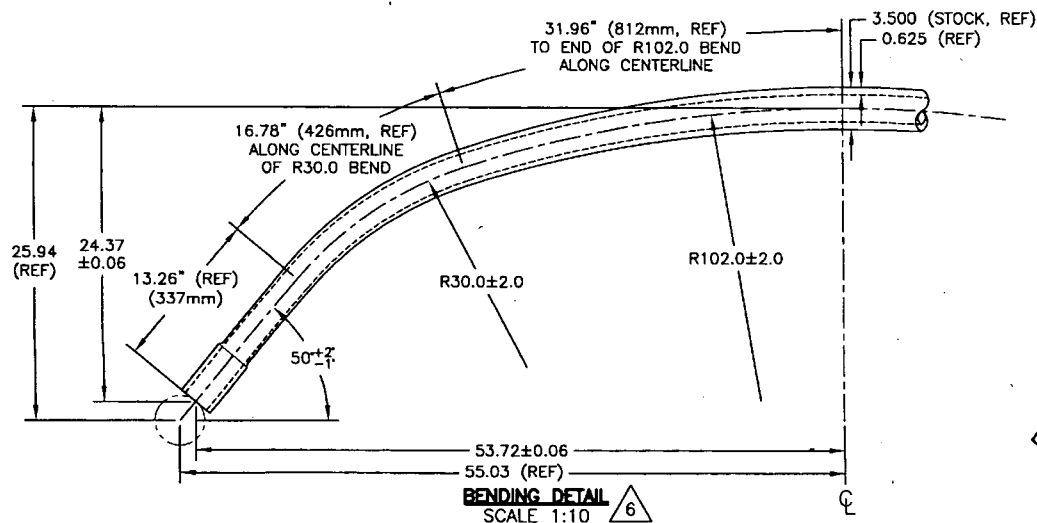
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR PACKAGING.
- 12) INSTALL MS21920-32 CLAMPS WITH D2732-058 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30424

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RELEASED

06.11.28

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DESIGN
PH
CHECKED
PH
DATE
06.10.27

DRAWN BY
B
APPROVED
H

DART

DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

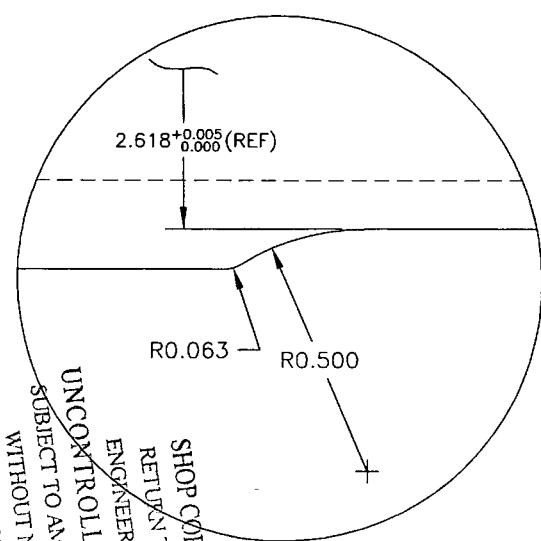
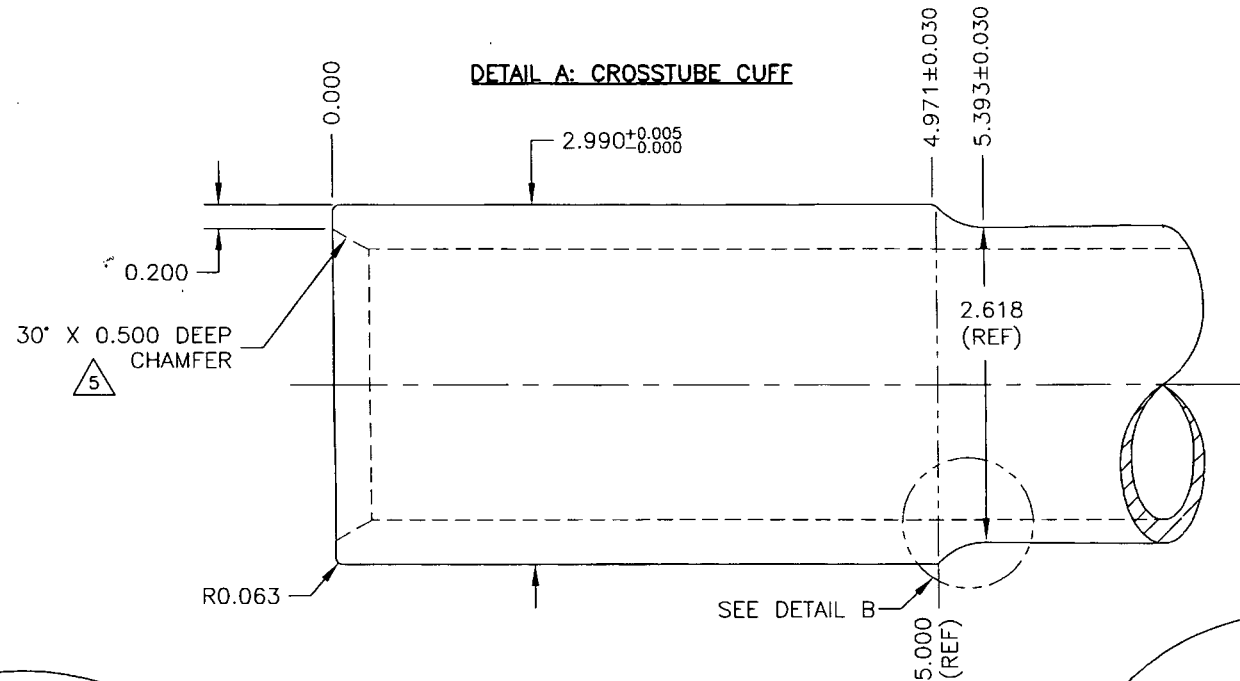
DRAWING NO.
D412-664-243

REV. C
SHEET 2 OF 3

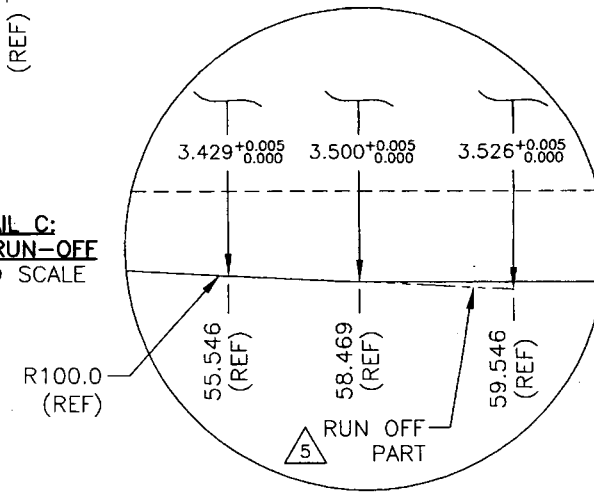
TITLE
CROSSTUBE ASSEMBLY (412 HI AFT)
SCALE
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NO. 30424
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UNCONTROLLED COPY
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RETURN TO
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SUBJECT TO AVIATION
WITHOUT NOTICE

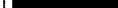
RELEASED
06.11.28



DETAIL C: TAPER RUN-OFF
NOT TO SCALE



NO. 30424
WORK ORDER
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DATE 06.10.27		DRAWING NO. D412-664-243		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	
				SCALE 1:1	



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36071

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (2) P/N D206-667-203 S/N's B30435 and B30432.

Qty (2) P/N D412-664-245 S/N's B31436 and B31140.

Qty (2) P/N D412-664-203 S/N B30426 and B30424.



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(6) cross tubes inspected. (6) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE

March 30, 2007

INSPECTION
STAMP(S)

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003449

ADDRESS:

CONTACT NAME:

Linda Lacelle

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

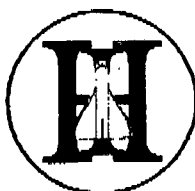
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PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

**HeathAir**

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NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

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Qty (2) P/N D412-664-203 S/N B30426 and B30424.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

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INSPECTION
STAMP(S)

N/R

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CONTACT NAME: Linda Lacelle

LABOUR

②

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MATERIALS

②

TRAVEL EXPENSES

②

GST

HOTEL EXPENSES

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